

Work Order ID 64356

Monday, December 06, 2010 3:24:44 PM

Page 1

Item ID: D4110-3

Accept

Setup Start

Revision ID:

Stop

Item Name: Doubler, Sill

Start Date: 12/2/2010 Start Qty: 8.00

Cust Item ID:

Required Date: 12/15/2010 Req'd Qty: 8.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 10-12-14

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4110

A

100

0.00



Waterjet

FLOW CNC Waterjet

304 .063

Memo

1-Cut as per Dwg

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

0.00

B10-12-17

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

B10-12-17

Work Order ID 64356

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Page 2

Item ID: D4110-3

Accept

Setup Start

Revision ID:

Stop

Item Name: Doubler, Sill

Start Date: 12/2/2010 Start Qty: 8.00

Cust Item ID:

Required Date: 12/15/2010 Req'd Qty: 8.00

Customer:




Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		8.012/17		(x8)			
130  Small Fab Small Fab	Memo 1- C'sink holes as per dwg	0.00 0.00							8.510/12/21 (8)
140  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		8.012/21		(x8) -3's			

Work Order ID 64356

Page 3

Monday, December 06, 2010 3:24:44 PM

Item ID: D4110-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler, Sill

Start Date: 12/2/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 12/15/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location: 130

0.00



Packaging

Memo

0.00

Packaging

10/12/21 (S)

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/12/21 JF

MF

10-12-21

Picklist Print

Monday, December 06, 2010 3:25:11 PM

Page 1

Work Order ID: 64356

Parent Item: D4110-3

Parent Item Name: Doubler, Sil.



Start Date: 12/2/2010

Required Date: 12/15/2010

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A 10.09.24 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	124.0000	0.1	0.842105			



304/316 Sheet .063



12-10-12-17

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT	124	
111323	0	
115953	124	

115953

8

DART AEROSPACE LTD		Work Order: 64356
Description: Doubler Sill		Part Number: D4110-3
Inspection Dwg: D4110-3, Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .128	+ .005 - .001	.128	✓		V 1302	
Ø .375	+ .006 - .001	.375	✓		V	
.19	± .030	.184	✓		V	
.75	± .030	.748	✓		V	
.76	± .030	.759	✓		V	
.254	± .010	.256	✓		V	
1.81	± .030	1.812	✓		V	
.91	± .030	.910	✓		V	
2.88	± .030	2.884	✓		V	
.254	± .010	.256	✓		V	
.508	± .010	.510	✓		V	
1.48	± .030	1.479	✓		V	
4.50	± .030	4.498	✓		V	
1.13	± .030	1.130	✓		V	
5.00	± .030	5.011	✓		V	
2.31	± .030	2.314	✓		V	
.063	± .010	.058	✓		V	

Measured by: IB
Date: 10-12-17

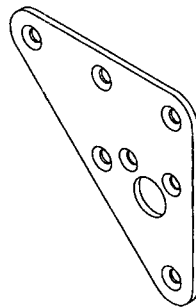
Audited by: S
Date: 10/12/17

Prototype Approval:
Date:

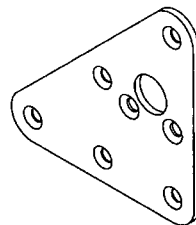
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

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 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 64356

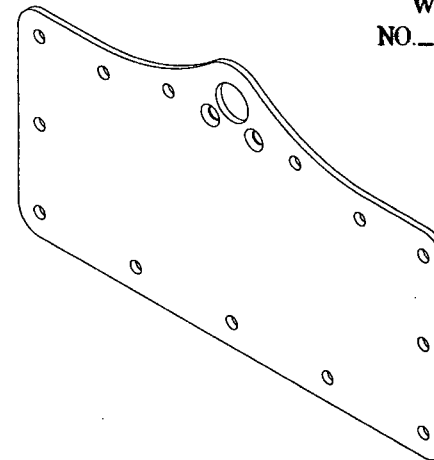
PS10-12C



D4110-1 DOUBLER, LH DOOR



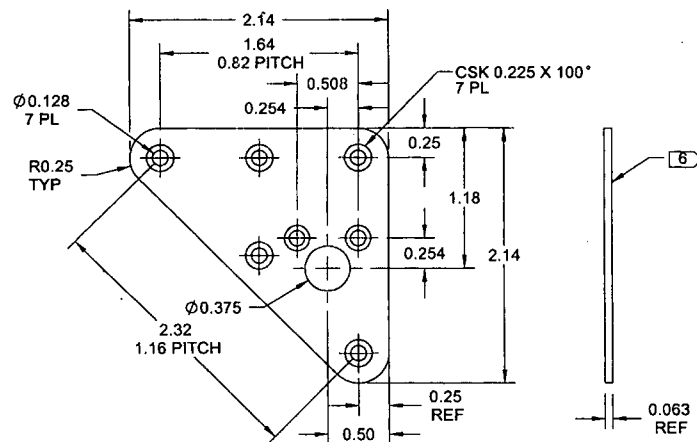
D4110-2 DOUBLER, RH DOOR



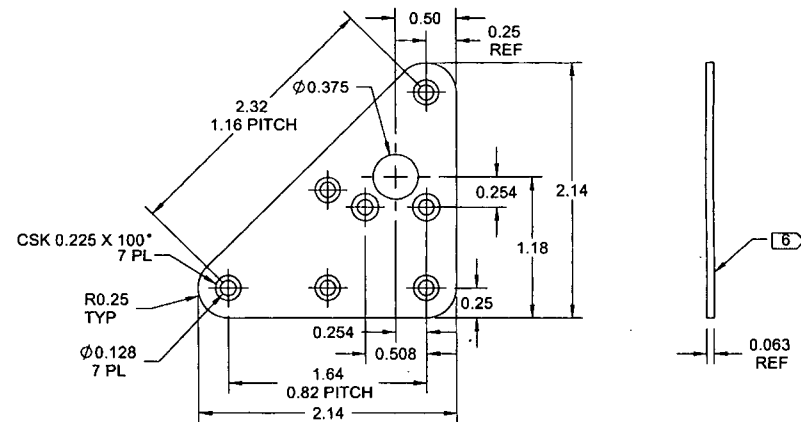
D4110-3 DOUBLER, SILL

RELEASED
 2010-09-23
AND

A	NEW ISSUE	JPH	10.07.20
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4110	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	DOUBLER	NTS
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D4110-1 DOUBLER, LH DOOR



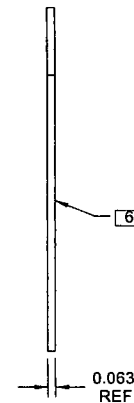
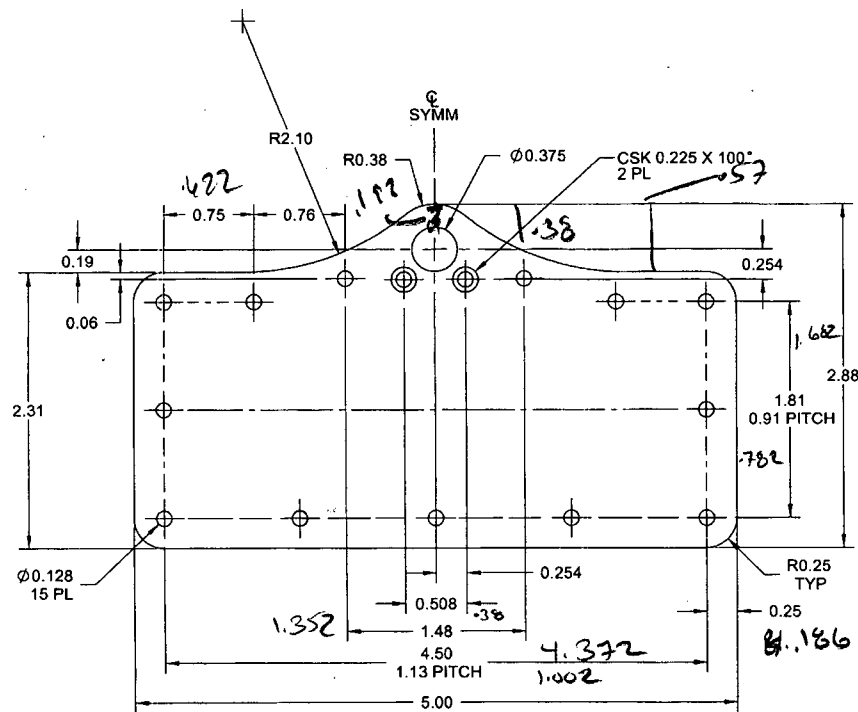
D4110-2 DOUBLER, RH DOOR

NOTES:

- 1) MATERIAL -1 & -2: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.063 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
PER DART SPEC M304S16GA OR M303S16GA
- 2) FINISH: NONE.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: IDENT P/N D4110-X & B/N PER QSI 044 6.1
- 7) WEIGHT -1 & -2: 0.05 lbs

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	JPH	DRAWING NO.	REV. A
MFG. APPR.	JPH	D4110	SHEET 2 OF 3
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RELEASED
2010-03-33



D4110-3 DOUBLER, SILL

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.063 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
PER DART SPEC M304S16GA OR M303S16GA
- 2) FINISH: NONE.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENT P/N D4110-3 & B/N PER QSI 044 6.1
- 7) WEIGHT: 0.21 lbs

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